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IS 1247 (1987): Handloom Cotton Madras Check [TXD 8:
Handloom and Khadi]



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Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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Indian Standard
SPECIFICATION FOR
HANDLOOM COTTON MADRAS CHECK
(*First Revision*)

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 RAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

Indian Standard

SPECIFICATION FOR HANDLOOM COTTON MADRAS CHECK (*First Revision*)

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Indian Standard
SPECIFICATION FOR
HANDLOOM COTTON MADRAS CHECK
(First Revision)

0. FOREWORD

0.1 This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards on 4 May 1987, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

0.2 This standard, which was first published in 1958, has been revised in order to specify the constructional particulars as in vogue presently. Other important change includes deletion of breaking strength values since the standard recommends the use of yarns conforming to IS : 171-1985*.

0.3 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test, shall be rounded off in accordance with IS : 2-1960†. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

1. SCOPE

1.1 This standard prescribes the constructional particulars and other requirements of handloom cotton Madras Check.

1.2 This standard does not specify the type of finish, general appearance, lustre and feel of cloth nor does it specify the colour or colour combination of check.

*Specification for cotton and cotton regenerated cellulosic fibre blended grey yarn (*third revision*).

†Rules for rounding off numerical values (*revised*).

2. MANUFACTURE

2.1 Yarn — The cotton yarn used in the manufacture of Madras Check cloth shall conform to the requirements of IS : 171-1985*.

2.2 Cloth — The cloth shall be free from substances liable to cause subsequent tendering.

3. REQUIREMENTS

3.1 The constructional particulars of Madras Check shall conform to those given in Table 1.

TABLE 1 CONSTRUCTIONAL PARTICULARS OF HANDLOOM COTTON MADRAS CHECK

Sl. No.	CHARACTERISTIC	REQUIREMENT		TOLERANCE	METHOD OF TEST
		Loomstate	Washed		
i)	Count of yarn (for guidance only)				
	Cotton count (Tex):				
	a) Warp	60 ^s (9·8)	60 ^s (9·8)	—	—
	b) Weft	40 ^s (14·8)	40 ^s (14·8)	—	—
ii)	Number of threads per decimetre:				IS : 1963-1981*
	a) Ends	330	340	± 5 percent	
	b) Picks	330	340	± 5 percent	
iii)	Mass, g/m ²	90	85	± 5 percent	IS : 1964-1970†
iv)	Dimensions:				IS : 1954-1969‡
	a) Length, m	As agreed		Not less than as declared or marked	
	b) Width, cm	As agreed		—2 percent	
v)	Weave	Plain	Plain	—	Visual

*Methods for determination of threads per unit length in woven fabrics (*second revision*).

†Methods for determination of weight per square metre and weight per linear metre of fabrics (*first revision*).

‡Methods for determination of length and width of fabrics (*first revision*).

*Specification for cotton and cotton regenerated cellulosic fibre blended grey yarn (*third revision*).

3.2 The cloth shall also conform to the requirements given in Table 2.

TABLE 2 REQUIREMENTS OF HANDLOOM COTTON MADRAS CHECK

SL No.	CHARACTERISTIC	REQUIREMENT	METHOD OF TEST
i)	Colour fastness rating to:		
a)	Light	4 or better	IS : 686-1985* or IS : 2454-1985†
b)	Washing: Test 4		
1)	Change in colour	4 or better	IS : 765-1979‡
2)	Staining on cotton	4 or better	
c)	Bleaching:		
1)	Change in colour	4 or better	IS : 762-1956§
2)	Staining on cotton	4 or better	
ii)	Dimensional changes, percent, M_{ax}		IS : 2977-1964
a)	Loomstate:		
1)	Warpway	5	
2)	Weftway	2	
b)	Washed:		
1)	Warpway	2.5	
2)	Weftway	1	
iii)	Scouring loss, percent, M_{ax}		IS : 1383-1977¶
1)	Loomstate	8	
2)	Washed	2.5	

*Method for determination of colour fastness of textile materials to day light (*first revision*).

†Method for determination of colour fastness of textile materials to artificial light (xenon lamp) (*first revision*).

‡Methods for determination of colour fastness of textile materials to washing: Test 4 (*second revision*).

§Method for determination of colour fastness of textile materials to hypochlorite bleaching.

||Methods for determination of dimensional changes of woven fabrics (other than wool) on soaking in water.

¶Methods for determination of scouring loss in grey and finished cotton textile materials (*first revision*).

3.3 If, in order to illustrate or specify the type of finish, general appearance, lustre and feel of cloth or to specify the colour or colour

combination of check, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respect.

3.3.1 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

4. INSPECTION

4.1 The cloth, when visually inspected, shall be reasonably free from following defects:

- a) More than two adjacent ends running parallel, broken or missing and extending beyond 20 cm;
- b) Weft crack or more than two missing picks across the width of the material;
- c) Prominently noticeable weft bar due to the difference in raw material, count, twist, lustre, etc;
- d) Noticeable selvage defects;
- e) Noticeable warp or weft float in the body;
- f) Noticeable oil and other stains;
- g) Noticeable hole, cut or tear up to 3 mm size;
- h) Smash rupturing the texture of the fabric;
- j) Undressed snarls noticeable throughout the piece;
- k) Conspicuous gout due to foreign matter usually lint or waste woven;
- m) Conspicuous broken pattern;
- n) Prominently noticeable dyeing defects; and
- p) Any other flaw which would mar the appearance or affect the serviceability and/or durability of cloth.

4.1.1 A reference may be made to IS : 4125-1967* for details of these defects.

5. MARKING

5.1 The cloth shall be marked with the following:

- a) Name of the material;

*Glossary of terms pertaining to defects in fabric.

- b) Manufacturer's name, initials or trade-mark, if any; and
- c) Length (m) and width (cm) of the piece.

5.1.1 The cloth may also be marked with the Standard Mark.

NOTE — The use of the Standard Mark is governed by the provisions of the Bureau of Indian Standards Act 1986 and the Rules and Regulations made thereunder. The Standard Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well-defined system of inspection, testing and quality control which is devised and supervised by BIS and operated by the producer. Standard marked products are also continuously checked by BIS for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.

6. PACKING

6.1 Unless otherwise agreed upon by the buyer and the seller, the cloth shall be packed in bales or cases in conformity with the procedure laid down in IS : 1347-1972* or IS : 293-1980†.

7. SAMPLING AND CRITERIA FOR CONFORMITY

7.1 The scale of sampling and criteria for conformity as given in IS : 3919-1966‡ shall be followed in respect of physical characteristics, namely, ends and picks, mass, dimension and weave.

7.2 The scale of sampling and criteria for conformity as given in IS : 5463-1969§ shall be followed in respect of chemical characteristics, namely, colour fastness, dimensional changes and scouring loss.

*Specification for inland packaging of cotton cloth and yarn (*first revision*).

†Specification for seaworthy packaging of cotton cloth and yarn (*third revision*).

‡Methods for sampling cotton fabrics for determination of physical characteristics.

§Methods for sampling cotton fabrics for chemical tests.

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*Sales Office in Bombay is at Novelty Chambers, Grant Road, Bombay 400007	89 65 28
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